

47

DART AEROSPACE LTD	Work Order:	21802
Description: Saddle billet	Part Number:	D6101-007
Drawing: D6101 Rev. A	Qty:	50

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	HA	04.10.22	50
2	PURCHASING	Issue P/O: 207012 a) Description: Alluminum billet b) 7.750" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 7.750" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	u	04.10.28	50
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	EC	05.05.03	50
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	EC	05.05.03	50
5	STORES	Identify & stock	EC	05.05.03	50
6	EXPEDITING	Close W/O Cost / part 95.18 545 05/05/04 102,18	HA	05.05.09	50

KF
3.06.05

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

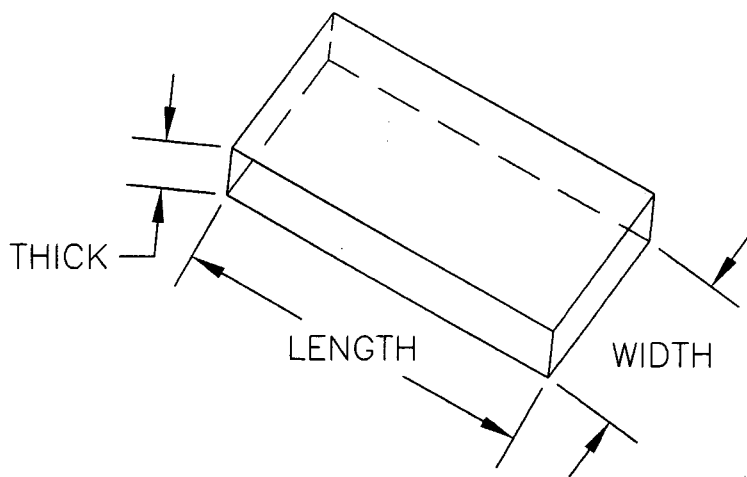
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
01.04.23 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 21802

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 21, 2004
03:29 pm

Work Order No	: 0021802	Department Code:	
Project Name	: D6101-007	Burden Flags	: NNNNNNNN
Project For	: WK447	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-007	Invoice Number	:
Description	: 7075-T7351 8.25X7.75X2.5	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 70	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 10-21-04	Actual Margin	: 0.000%
Est Finish Date	: 11-25-04		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

371899	74021				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page 1
2005-03-16	71717	01027	DS-86175-1		
P.O. No./Govt Contract No.	Customer				
CC8973	C&B-WALLINGFORD				

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description
2.5000 IN TK X 48.500 IN W X 144.500 IN LN CAT D 164168 (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED {{ P/N 091557-9 }}. PER AMS-QQ-A-250/12
& EXCEPT MARKING MMS159 REV N &
EXCEPT MARKING AMS4078 REV F & EXCEPT MARKING
ASTMB209 REV 04 & EXCEPT MARKING BSS7055 REV A & AMS-STD-
2154 & EXCEPT MARKING ASTMB594 REV 02 &
EXCEPT MARKING PS21211 REV J ((MARKED))
INTERLEAVED SKID WGT: 3500 LB QUAN TOL
+/-10 % USI CL A 3 MM CQR D164168 REV 12 CUST REQ 05-03-
14 *** W/E 05-03-19 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	266658	309821	3530	2	PC	

Notes for CQR: D164168.12
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12. THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I. PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.

CQR: D164168.12 -Specification Limits -----

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0 52.0	6
T7351 Elec. Cond. (EC) % MIN 38.0 PCT				

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum
Alloy 7075	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05	.15
	Min			1.2		2.1	.18	5.1			REMAIN

Lot: 309821 -Mechanical, Physical, Metallography, Quantometer Results -----

No.	UTS	TYS	EL4D
Test	KSI	KSI	PCT
T7351 Long Transv. 3	Max	71.3	61
	Min	70.6	60.5

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Mark J. Vrablec

Mark J. Vrablec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

371899

Ship Date

2005-03-16

P.O. No./Govt Contract No.

CC8973

74021

B.L. No.

71717

Invoice No.

01027

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-86175-1

Page 2

Lot: 309821 - Mechanical, Physical, Metallograpy, Quantometer Results (cont.) -----

T7351 Elect Cond %IACS 40.8 41.0 40.9 PCT

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9746053	Actuals	.06	.28	1.6	.02	2.4	.19	5.6	.02